

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
19 May 2005 (19.05.2005)

PCT

(10) International Publication Number
WO 2005/044502 A1

(51) International Patent Classification⁷: **B23K 9/09**

Kristinehamn (SE). **LÖFGREN, Hannes** [SE/SE]; Ug-
glegatan 1, S-696 33 Askersund (SE).

(21) International Application Number:

PCT/SE2004/001634

(74) **Agent: NILSSON, Kent**; Esab AB, Esabvägen, S-695 81
Laxå (SE).

(22) International Filing Date:

8 November 2004 (08.11.2004)

(81) **Designated States** (*unless otherwise indicated, for every
kind of national protection available*): AE, AG, AL, AM,
AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN,
CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI,
GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE,
KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD,
MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG,
PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM,
TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM,
ZW.

(25) Filing Language:

Swedish

(26) Publication Language:

English

(30) Priority Data:

0302946-9

7 November 2003 (07.11.2003) SE

(71) **Applicant** (*for all designated States except US*): **ESAB AB**
[SE/SE]; Box 8004, Herkulesgatan 72, S-402 77 Göteborg
(SE).

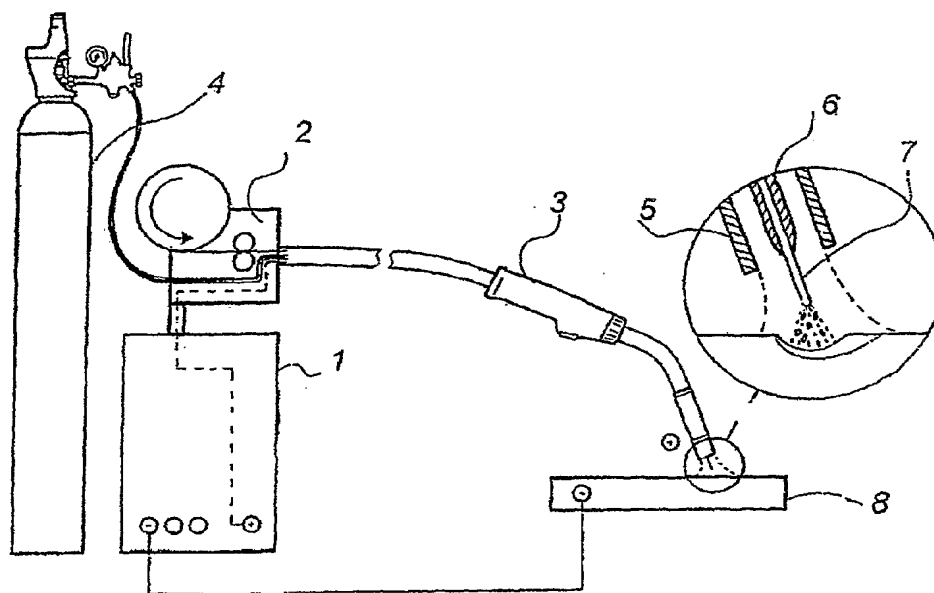
(72) Inventors; and

(75) **Inventors/Applicants** (*for US only*): **ÅBERG, Per**
[SE/SE]; Hjortronstigen 2, S-695 30 Laxå (SE). **CARLS-
SON, Thomas** [SE/SE]; Brattsands Gård, S-681 93

(84) **Designated States** (*unless otherwise indicated, for every
kind of regional protection available*): ARIPO (BW, GH,
GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM,
ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI,
FR, GB, GR, HU, IE, IS, IT, LU, MC, NL, PL, PT, RO, SE,

[Continued on next page]

(54) **Title:** METHOD, APPARATUS AND SOFTWARE FOR GAS METAL ARC WELDING WITH A CONTINUOUSLY FED
ELECTRODE



(57) **Abstract:** The invention relates to a welding method for gas metal arc welding with continuous electrode feeding with process control for short arc welding and/or spray arc welding, and also for short pulsing in which the process control according to the short pulse method is caused to alternate cyclically between this and the process control for short arc or spray arc welding and in which the time for at least one of these process control methods is determined by a time programmed in by the user. The invention also relates to a welding power source and software for carrying out said method.

WO 2005/044502 A1



SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

Published:

— *with international search report*